

Work Order ID 133313

Tuesday, June 02, 2015 2:49:32 PM

D2563
B133313
REV. C

133313

Page 1

Item ID: D2563

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment Assembly

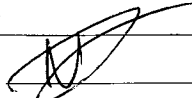
Start Date: 6/03/15 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 6/12/15 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan:  Date: 15-6-7 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2563	Rev C

100 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

4X Dh 15/6/3

4 DAS 43 9-89 JUN 05 2015

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

④ 15.06.09 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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133313

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/03/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 6/12/15 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

OC

Memo

0.00

Quality Control

DAS

9

9-89

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

DAS 34 38

DQA: _____ Date: _____



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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 133313

133313

Page 5

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Item ID: D2563 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment Assembly
 Start Date: 6/03/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/12/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							DAS 38 9-89
200									
QC	Memo	0.00							
Quality Control									JUL 03 2015
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging	Memo	0.00							DAS 9-89 JUL 07 2015
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							MLJ JUL 08 2015
Quality Control									

MLJ JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 133313

133313

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/03/15

Required Date: 6/12/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured

No

100

Each

147.3200

1

4

D2244-116

STEP EXTRUSION

**

DL 15/6/13

Location

Loc Qty

Loc Code

HALL

138

117818

138

WA003

9.3199632

104940

9.32

D2561

Manufactured

No

100

Each

23.0000

2

8

D2561

Lug

**

DL 15/6/13

Location

Loc Qty

Loc Code

WA003

23

129516

3

131074

20

D2564

Manufactured

No

100

Each

25.0000

2

8

D2564

Mounting Angle

**

DL 15/6/13

Location

Loc Qty

Loc Code

WA003

25

130030

1

131112

24

D2673-34

Manufactured

No

100

Each

27.0000

1

4

D2673-34

End Plate

**

DL 15/6/13

Location

Loc Qty

Loc Code

WA003

27

128133

27

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 2

Work Order ID: 133313

133313

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/03/15

Required Date: 6/12/15

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

150

Each

27.0000

1

4

D2673-34

**

DL 15/6/3

End Plate

Location

Loc Qty

Loc Code

WA003

27

128133

27

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

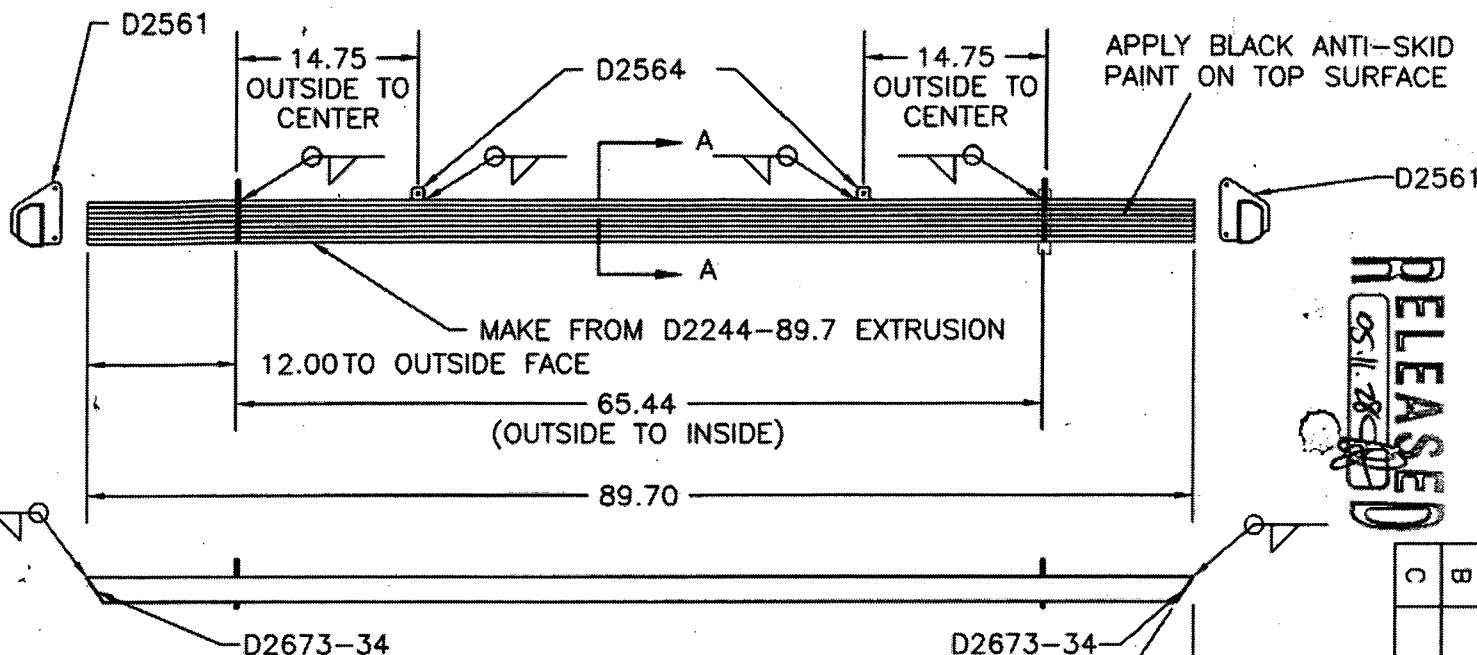
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RELEASED
05.11.28

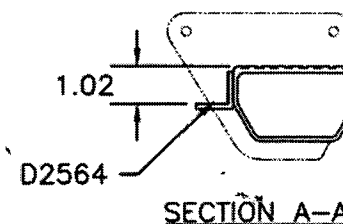
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	44	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
44	44	D2563	
DATE		TITLE	SCALE
05.11.14		STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED